

Date: Monday, 1/23/2006 7:55:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 25593	
Estimate Number : 10178	
P.O. Number : N/A	Part Number : D25941
This Issue : 1/23/2006 S.O. No. : N/A	Drawing Number : D2594 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 24374	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 2/7/2006
Checked & Approved By : SEE ABOVE DATE & USER	Qty: 500 Um: Each
Comment : Est D 02.08.22 Make in Cobra KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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0.660



Comment: Qty.: 0.0547 f(s)/Unit Total: 27.3525 f(s)

Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)

1100-0 (QQ-A-225/1) Ø0.625" Rod

(M5052H32R0.625) or (M6061T6R0.625)

Batch M18740 4q"

M18740 4q"

M19681

M8 06/02/24

500

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Make as per Dwg D2594-1 and Folio FA262.

2-Break all sharp edges 0.010 max.

M8 06/02/24

M8 06/02/24

J.G. 06/02/26 500

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

J.G. 06/02/26 500

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1

A.M. 06-03-01

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

G.M. 06-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/03/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 03 02 500

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

FC 06 03 08

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06 03 03

Job Completion



u 06-03-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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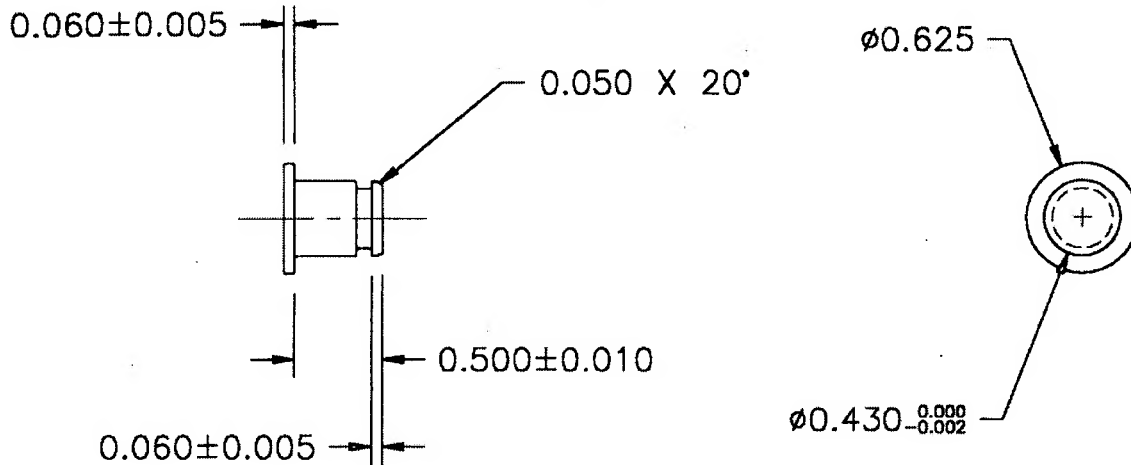
NOTE: Date & initial all entries



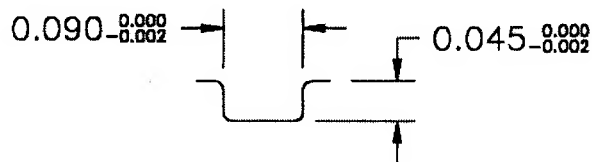
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD Powder coat, QSE 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-0

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSE 005 4.3

PER QQ-A-225 / 7 (5052)
OR QQ-A-225 / 8 (6061)
OR QQ-A-225 / 1 (1100)
OR QQ-A-200 / 8 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG
(1) D2594-3 O-RING